

Work Order ID 128138

Thursday, January 08, 2015 9:09:36 AM

Rush - ship ASAP 30/01
128138

Page 1

Item ID: D350-636-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/8/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 1501-08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4168-041	B								

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

record fwd angle:

89.5° DG

FEB 13 2015

DAS
46
9-89

Photocopy blue file and type labels per PPP D350-636-015 CHG 005

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Item ID: D350-636-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/8/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D4168 sheet 4 (D4168-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section H-H. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	5- Drill fwd step holes using DT9616. Ensure proper positioning. All holes as per dwg D4168, detail A								
	6- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole.								
	7- Open up holes of Detail A to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side)								
	8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left								

DGL 15-1-8

DGL 15-1-8

DGL 15-1-8

BE 15-01-13

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Item ID: D350-636-015

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop *NS2*

Start Date: 1/8/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/8/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

from bending as per QSI 004
A/R Aluminum Rod batch: m130812

9- Grind welds flush as per Dwg D4168

7 BE 15-01-13

120 QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Memo

Quality Control

15-01-14

DAS
9
9-89

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

Quality Control

15-01-14

DAS
9
9-89

128138

Thursday, January 08, 2015 9:09:36 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/8/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/8/2015 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							

140

HandFinish

Memo

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

150

QC

Memo

Quality Control

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Item ID: D350-636-015

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N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/8/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes using hole saw of Detail C and ground handling section AL-AL to 0.625" (total of 8 holes per side) as per dwg D4168.								
	2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D4168.								
	3- Open float hole to 0.500" using uni-bit (4 per side) section AJ-AJ								
	Open wearplate holes to size as per dwg (4 holes per sides) , section CG-CG								
	4-Chamfer holes of Detail B, C, ground handling section AL-AL and float holes section AJ-AJ per dwg D4168 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 131120 exp. date: 15-10-21								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: MA308/2								
	9- At section AJ-AJ drill out x-bolt spacer to 0.404"								

DGL

13-1-15.

DGL

15-1-15.

7 BE 15-01-27

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Thursday, January 08, 2015 9:09:36 AM

Item ID: D350-636-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop ***NS2***

Start Date: 1/8/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/8/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

10-Grind welds flush as per Dwg D4168

11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168, section AL-AL

12- C'bore section CG-CG. ADJUST TOOLING AS REQUIRED.
VERF BY: DD

13- Deburr holes, ensure tube is free of all scratches before sending to paint.

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING
HOLE IN TUBE **********REF TO W/O BATCH: N/A *****

170

QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo

0.00

Quality Control

DAS
38
9-89

15-01-04

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Thursday, January 08, 2015 9:09:36 AM

Item ID: D350-636-015 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/8/2015 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***VERIFY C'BOARD IS GOOD***	0.00 0.00				1			OKS 38 9-89 15-01-04
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.00							15-2-4 JH/DeL
200 *200* SprayPaint Spray Painting	 Memo 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 130 992 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 131 233	0.00 0.00				1			OK 15-02-05

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 Revision ID: Stop *NS2*
 Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/8/2015 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* QC Quality Control	QC14- Inspect Spray Paint Memo Inspect for foreign object per QSI 024	0.00 0.00				144	1	11/15/02/05	DAS 15 9-89
230 *230* HandFinish Hand Finishing	HandFinishing Memo 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: 11131120 EXP DATE: 12/02 4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: 11129305 1240 598 5112 1125-792 04/15/10 5-Coat all exposed fasteners with "LPS Procyon" batch: 11122900	0.00 0.00				144	1	11/15/02/12	

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Item ID: D350-636-015 Accept *N900040100* Setup Start *NS1*
 Revision ID:
 Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Stop *NS2*
 Compatible

Start Date: 1/8/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/8/2015 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			DAS 38 9-89 15-02-12
250 *250* Packaging Packaging	Pick Kit Memo If making a D350-636-215 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1	0.00 0.00							DAS 27 9-89 FEB 13 2015
260 *260* QC Quality Control	QC4- 100% Inspect kits for completeness Memo *****ensure antiseize is on AN8C21A bolts*****	0.00 0.00				1			DAS 46 9-89 FEB 12 2015

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Thursday, January 08, 2015 9:09:36 AM

Item ID: D350-636-015 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/8/2015 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-015								
	Location: _____								
	PPP rev: _____								
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

FEB 13 2015

DAS
46
9-89

MLD 1502-13

ME
15-2-13

Picklist Print

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Page 1

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Work Order ID: 128138

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Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B
11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per
NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN 12-
542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C34A		Purchased	No			230	Each	13.0000	1	1			
AN3C34A									**				
BOLT													

11 1202105

Location	Loc Qty	Loc Code
ST347	13	
m127044	13	

AN3C36A	Purchased	No	230	Each	145.0000	4	4	**
---------	-----------	----	-----	------	----------	---	---	----

AN3C36A
Bolt

11 1202105

Location	Loc Qty	Loc Code
FG	24	
101261	4	
116590	10	
122204	10	
FP001	27	
m129907	27	
ST338a	50	
m130874	50	
ST348	44	
m129907	44	

14

Picklist Print

Thursday, January 08, 2015 9:09:42 AM

Work Order ID: 128138

128138

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

D3492-1 Manufactured No 230 Each 173.0000 8 8 Start Qty: 1.00 Required Qty: 1.00

D3492-1

Plug

**

lll 15/02/05

Location

Loc Qty

Loc Code

FP001

173

B129057

x8

125904

173

D3492-3

Manufactured No

230 Each

194.0000 8 8

D3492-3

Plug

**

lll 15/02/12

Location

Loc Qty

Loc Code

FP001

194

B128476

x2

125905

194

D3873-1

Manufactured No

230 Each

91.0000 7 7

D3873-1

Bushing

**

lll 15/02/05

Location

Loc Qty

Loc Code

FP001

42

124192

42

ST063

49

126709

49

x7

D4154-041

Manufactured No

230 Each

7.0000 1 1

D4154-041

Wearplate Assembly

**

lll 15/02/05

Location

Loc Qty

Loc Code

FP002

7

120226

7

41

Picklist Print

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Work Order ID: 128138

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Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

D4170-1 Manufactured No 230 Each 166.0000 4 4

Start Qty: 1.00

Required Qty: 1.00

D4170-1

Bushing

**

845-01-27

Location

Loc Qty

Loc Code

LG001

166

107896

89

119639

44

123940

33

4

D4171-1 Manufactured No 230 Each 7.0000 1 1

D4171-1

Bushing

**

15102/17

Location

Loc Qty

Loc Code

ST096

7

125038

7

X1

MS21043-3 Purchased No 230 Each 426.0000 5 5

MS21043-3

Nut

**

12102/12

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

294

m130673

294

X5

GA

52

m130673

52

Picklist Print

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Work Order ID: 128138

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Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

NAS1149C0363R

Purchased

No

230

Each

Start Qty: 1.00
962.0000 9 9

Required Qty: 1.00

NAS1149C0363R

Washer

**

Handwritten: 15/02/17

Location

Loc Qty

Loc Code

FP001

221

114742

221

Handwritten: X9

GA

228

m130673

228

ST271

513

m130673

513

NAS1515H3L

Purchased

No

230

Each

687.0000 4 4

***NAS1515H3L ***

Washer

**

Handwritten: 12/02/12

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

91

m127831

91

ST266

556

m127831

56

m130726

500

Handwritten: X4

NAS1611-010

Purchased

No

230

Each

172.0000 8 8

NAS1611-010

O-RING

**

Handwritten: 15/02/12

Location

Loc Qty

Loc Code

FP001

172

m130797

172

Handwritten: 1131324

Handwritten: X8

Picklist Print

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Work Order ID: 128138

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Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

NAS1611-013

Purchased

No

230

Each

Start Qty: 1.00
942.0000 8 8

Required Qty: 1.00

NAS1611-013

O-RING

**

ll 15/02/15

AN3C37A

Purchased

No

250

Each

170.0000

**

DAS
27
9-89

AN3C37A

BOLT

DAS
46
9-89

Location

Loc Qty

Loc Code

FP001

942

m130758

942

X 8
1

Location

Loc Qty

Loc Code

ST338a

170

M128773

80

M129650

90

1

FEB 13 2015

AN3C42A

Purchased

No

250

Each

40.0000

**

DAS
27
9-89

AN3C42A

Bolt

DAS
46
9-89

Location

Loc Qty

Loc Code

FG

5

121103

5

ST347

35

m130460

5

m130485

30

m130485
130485

FEB 13 2015

Picklist Print

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Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

NAS1149D0863J

Purchased

No

250

Each

Start Qty: 1.00
758.0000 2

Required Qty: 1.00

NAS1149D0863J

Washer

DAS
46
9-89

**

FEB 19 2015

Location

Loc Qty

Loc Code

FP001

57

125484

57

ST260a

700

125268

600

125635

100

st268

1

125268

1

D2744

Manufactured

No

110

Each

38.0000

1

1

D2744

Cap

**

BCP 15-01-13

Location

Loc Qty

Loc Code

LG001

38

125894

38

D2600-3-BENT-LH

Manufactured

No

110

Each

4.0000

1

1

D2600-3-BENT-LH

Extrusion Bent LH

**

Location

Loc Qty

Loc Code

LG002

4

125886

4

D2743

Manufactured

No

160

Each

155.0000

8

8

D2743

Crossbolt Spacer

**

BCP 15-1-8

BCP 15-01-27
B128350 x8

Location

Loc Qty

Loc Code

LG001

155

125893

8

127636

147

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Shop Packet Print

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Parent Item: D350-636-015

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Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

D2739 Manufactured No 160 Each 10.0000 1 1 Start Qty: 1.00 Required Qty: 1.00

D2739

350 I Beam

**

Location	Loc Qty	Loc Code
LG003	10	
125889	10	

DGL 15-1-15

D3490-3

Manufactured No

160 Each 107.0000 4 4

D3490-3

Cross Bolt Spacer

**

Location	Loc Qty	Loc Code
LG001	107	
125903	107	

BE 15-01-27

D3490-1

Manufactured No

160 Each 117.0000 4 4

D3490-1

Cross Bolt Spacer

**

Location	Loc Qty	Loc Code
LG001	117	
125902	117	

BE 15-01-27

ALS4-1032-225

AELS8-1032-225 Purchased

No

230 Each 1,546.000 4 4

AI S4-1032-225

Rivnut

**

Location	Loc Qty	Loc Code
FG	120	
M127028	120	
FP001	622	
M131067	622	
st549	804	
M131067	804	

X L

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Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

AN8C35A Purchased No 230 Each 25.0000 1.00 1.00
AN8C35A **
 Bolt

Location	Loc Qty	Loc Code
FG	5	M131367
121275	5	
FP001	20	
m130114	1	
m130784	19	

D3488-041 Manufactured No 230 Each 12.0000 1.00 1.00
D3488-041 **
 Blade Fitting LH

Location	Loc Qty	Loc Code
FP001	12	
124200	1	
125897	6	
125898	5	

AN6C44A Purchased No 230 Each 102.0000 4.00 4.00
AN6C44A **
 Bolt

Location	Loc Qty	Loc Code
FG	2	M131546
103964	2	
FP001	4	
m130863	4	
ST286A	17	
m130863	17	
ST332	11	
m130863	11	
ST333	68	
m131151	68	

Picklist Print

Page 9

Thursday, January 08, 2015 9:09:43 AM

Work Order ID: 128138

128138

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

MS21083C8	Purchased	No	230	Each	114.0000	1	1	Start Qty: 1.00	Required Qty: 1.00
MS21083C8								**	lll 15/02/12
Nut									

Location	Loc Qty	Loc Code
----------	---------	----------

ST300	114	
-------	-----	--

m131049	114	
---------	-----	--

D3631-1	Manufactured	No	230	Each	170.0000	8	8		
D3631-1								**	lll 15/02/12
Washer									

Location	Loc Qty	Loc Code
----------	---------	----------

FP001	170	
-------	-----	--

125912	170	B128320
--------	-----	---------

NAS1149C0332R	Purchased	No	230	Each	4,371.000	4	4		
NAS1149C0332R								**	lll 15/02/12
WASHER									

Location	Loc Qty	Loc Code
----------	---------	----------

FP001	2581	
-------	------	--

m130325	2581	M131340
---------	------	---------

GA	126	
----	-----	--

125654	126	
--------	-----	--

ST271	1664	
-------	------	--

m130325	664	
---------	-----	--

m130466	1000	
---------	------	--

D2745	Manufactured	No	230	Each	76.0000	8	8		
D2745								**	lll 15/02/12
Bushing									

Location	Loc Qty	Loc Code
----------	---------	----------

ST010	76	
-------	----	--

125895	76	B127585
--------	----	---------

Thursday, January 08, 2015 9:09:43 AM

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Thursday, January 08, 2015 9:09:43 AM

Work Order ID: 128138

128138

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

NAS1149C0832R

Purchased

No

230

Each

189.0000

1

1

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Washer

**

all 13/02/12

Location

Loc Qty

Loc Code

FP001

45

m114915

45

xl

ST271

144

m125807

144

AN3C6A

Purchased

No

230

Each

608.0000

4

4

AN3C6A

Bolt

**

all 15/02/12

Location

Loc Qty

Loc Code

CA

39

m128704

39

FG

10

122416

10

FP001

118

m128769

118

xd

ST338a

441

m128769

441

MS21043-6

Purchased

No

230

Each

206.0000

4

4

MS21043-6

NUT

**

all 15/02/12

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

186

m130325

6

m130726

180

xd

Picklist Print

Thursday, January 08, 2015 9:09:43 AM

Work Order ID: 128138

128138

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

D3493-1 Manufactured No 250 Each 109.0000 **Start Qty: 1.00** **Required Qty: 1.00**

D3493-1

Washer

DAS
46
9-89

**

DAS

27

9-89

FEB 13 2015

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

99

125906

99

250

Each

114.0000

**

DAS

27

9-89

FEB 13 2015

MS21083C8

Purchased

No

MS21083C8

Nut

DAS
46
9-89

**

DAS

27

9-89

FEB 13 2015

Location

Loc Qty

Loc Code

ST300

114

1131049

114

250

Each

20.0000

**

DAS

27

9-89

FEB 13 2015

AN8C21A

Purchased

No

AN8C21A

Bolt

DAS
46
9-89

**

DAS

27

9-89

FEB 13 2015

Location

Loc Qty

Loc Code

FG

2

123966

2

ST332

18

m131100

18

Picklist Print

Page 12

Thursday, January 08, 2015 9:09:43 AM

Work Order ID: 128138

128138

Parent Item: D350-636-015

D350-636-015

Parent Item Name: Skidtube LH with Run-on Landing Wearplates, DART (Apical)
Cylindrical/Aerazur Float Compatible

Start Date: 1/8/2015

Required Date: 1/8/2015

D2741

Manufactured No

250

Each

11.0000

Start Qty: 1.00

Required Qty: 1.00

D2741
Replacement Blade

DAS
46
9-89

**

DAS
27

Location

Loc Qty

Loc Code

FG

10

100664

3

113640

2

115522

5

ST538

1

124047

1

B12890

FEB 13 2015

Thursday, January 08, 2015 9:09:43 AM

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Page 12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

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OFFICE
UNDER
128138 MCT
1501-08

RELEASE
2013-08-13
AMP

- 1) MATERIAL: MAKE D4168-1/2-3/4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0" ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN 44-54-56-77), UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757		MB	13.07.11
A	NEW ISSUE		SC	10.08.09
REV.	DESCRIPTION		BY	DATE
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DRAWN	<i>JB</i>	KENT, WA		
CHECKED	<i>JB</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>JB</i>	D4168	SHEET 1 OF 11	
APPROVED	<i>JB</i>	TITLE	SCALE	
DE APPR.	<i>JB</i>	350 SKIDTOUBE ASSEMBLY	NTS	
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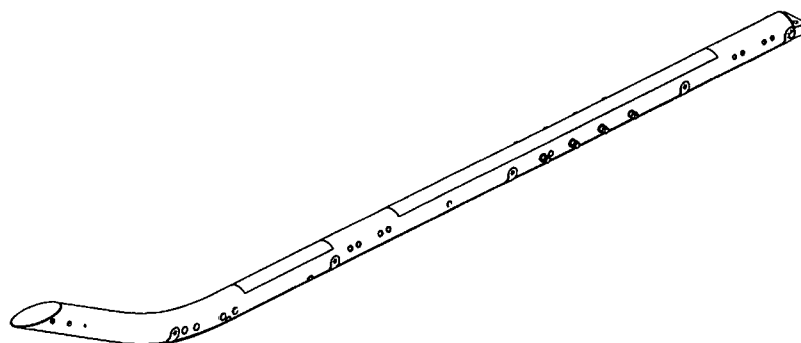
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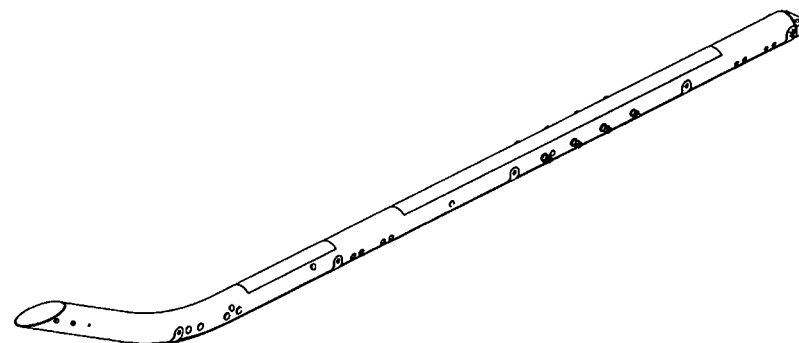
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D4168-041 350 SKIDTUBE ASSEMBLY, LH

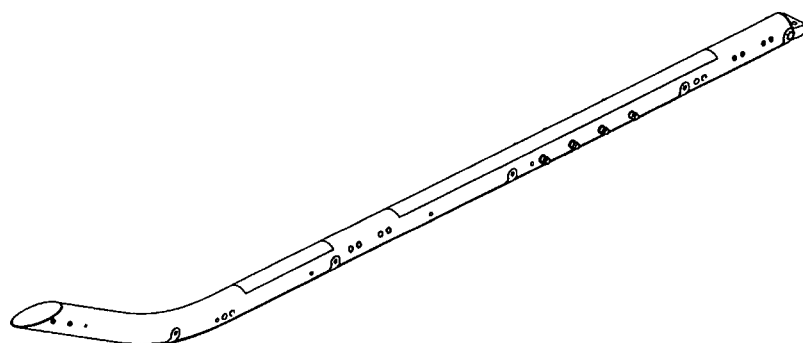


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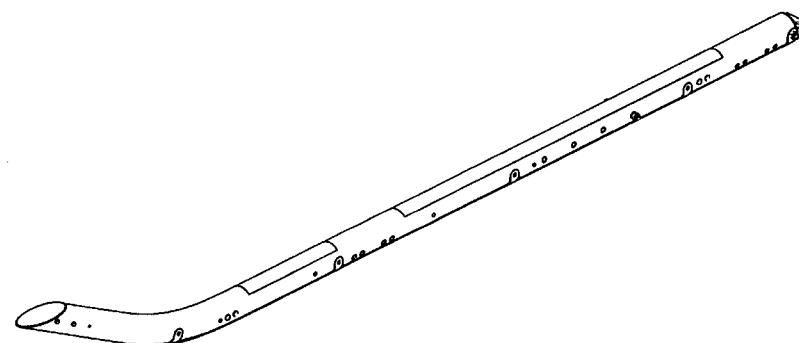
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MFG. APPR.	<i>SC</i>	D4168	SHEET 2 OF 11
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D4168-043 350 SKIDTUBE ASSEMBLY, LH

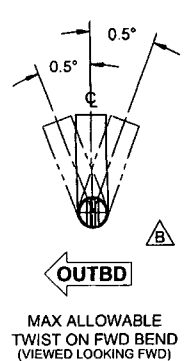
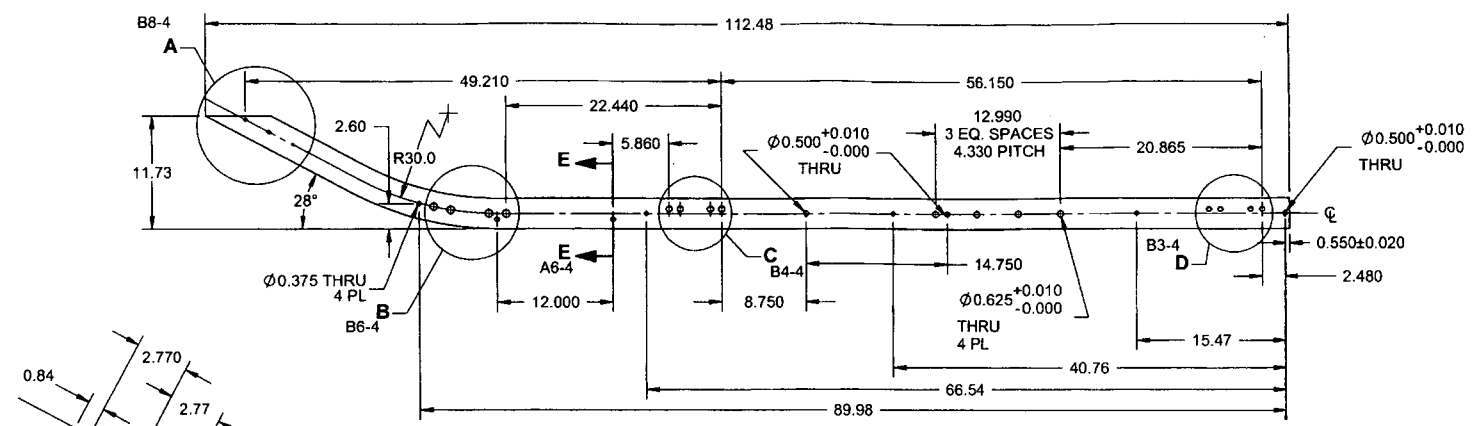


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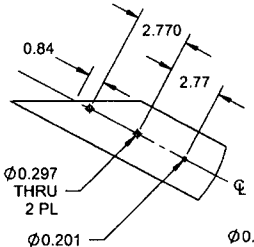
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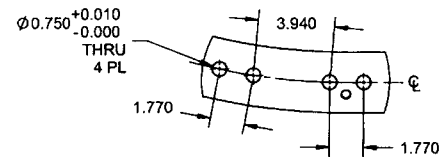
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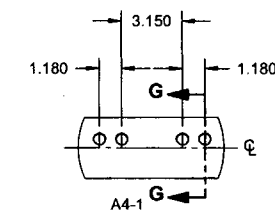
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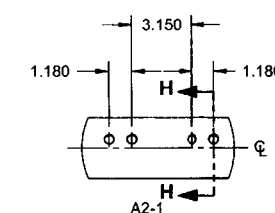
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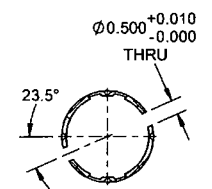
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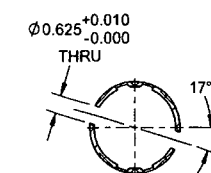
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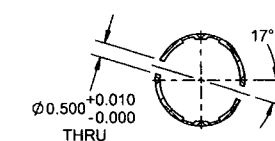
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SECTION E-E
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SECTION G-G
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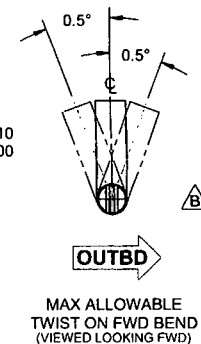
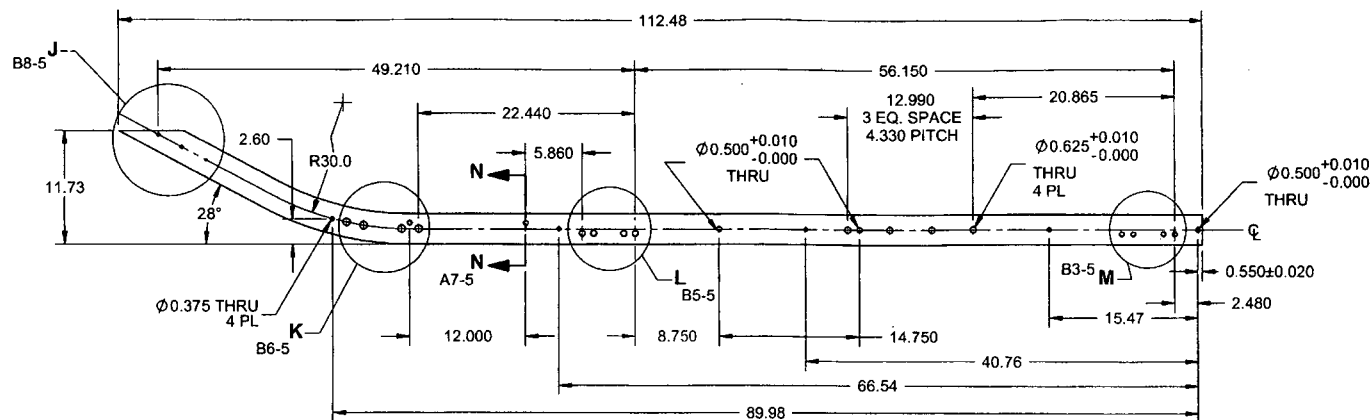


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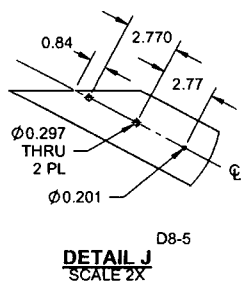
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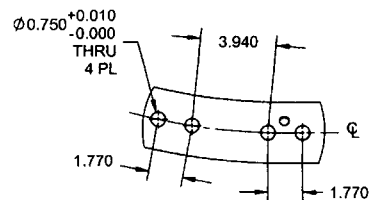
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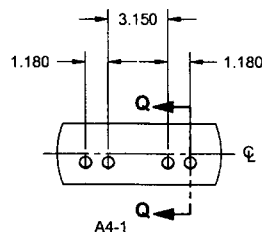
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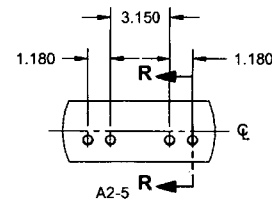
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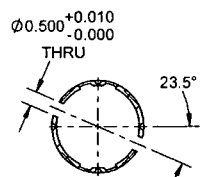
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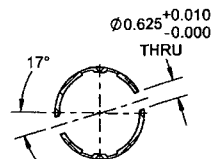
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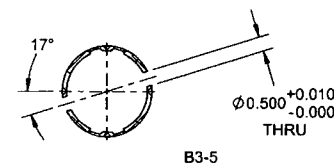
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SECTION N-N
SCALE 3X, 2 PL



SECTION Q-Q
SCALE 3X, 4 PL

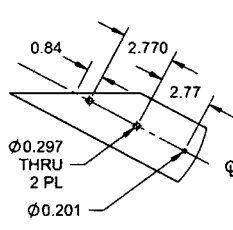
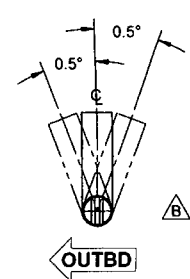
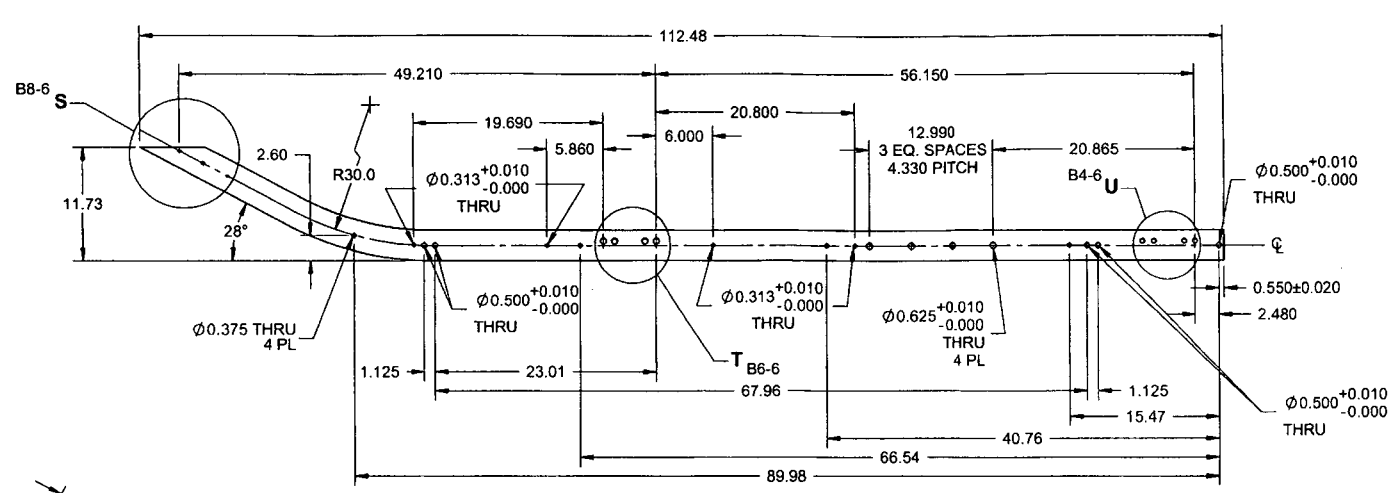


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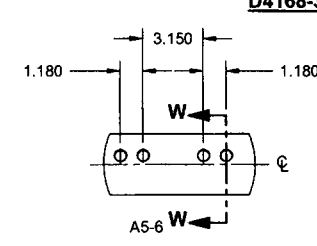
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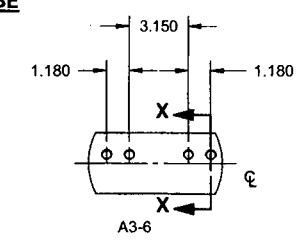
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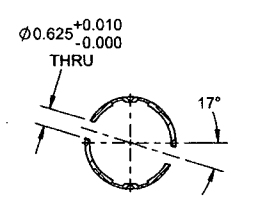
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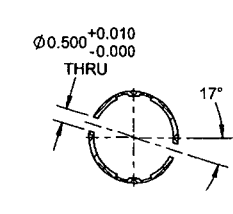
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DETAIL U
SCALE 2X



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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MFG. APPR.			SCALE
APPROVED			NTS
DE APPR.			
DATE	13.07.11		

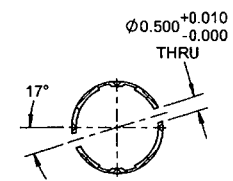
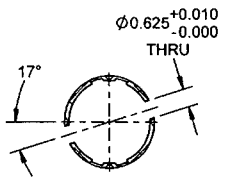
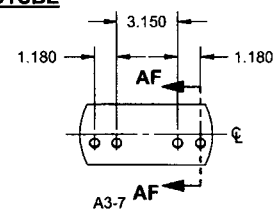
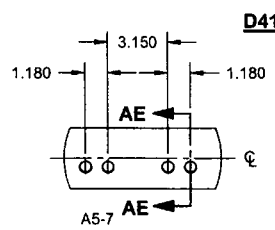
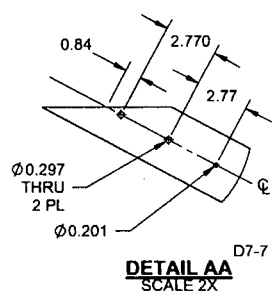
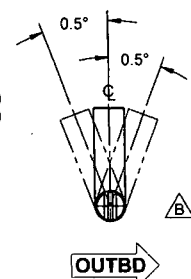
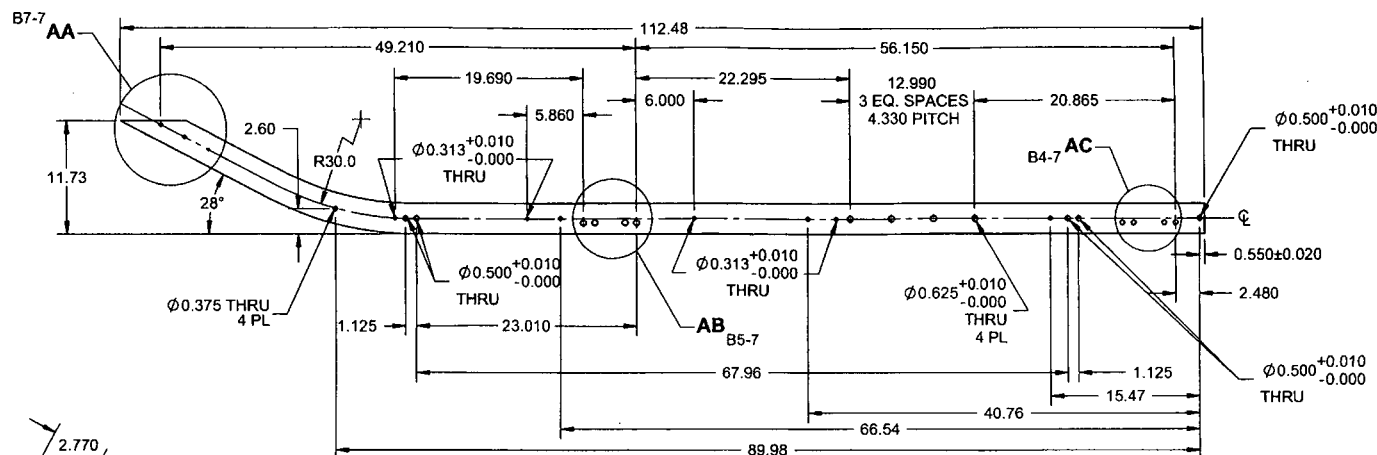
D4168

350 SKIDTUBE ASSEMBLY

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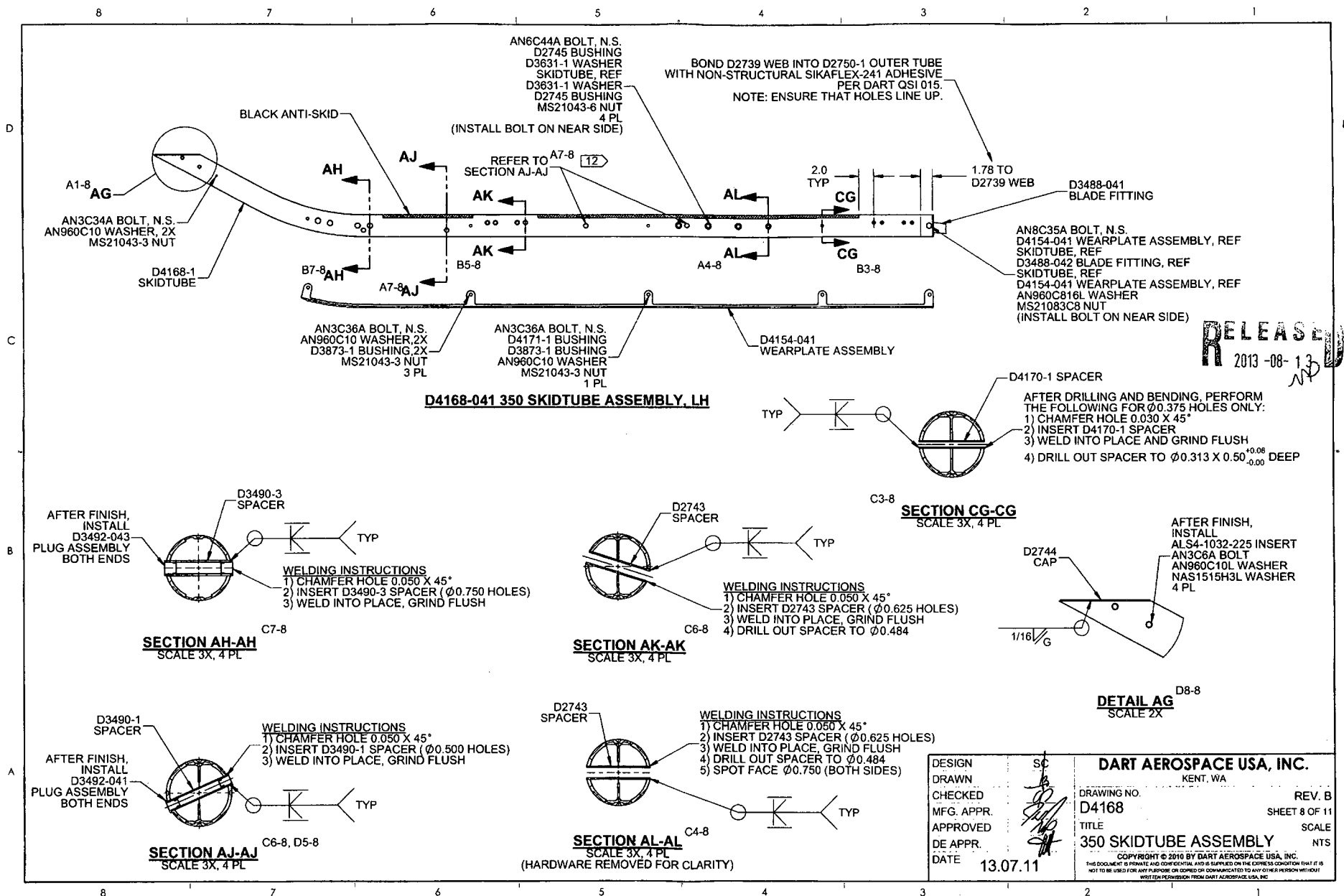
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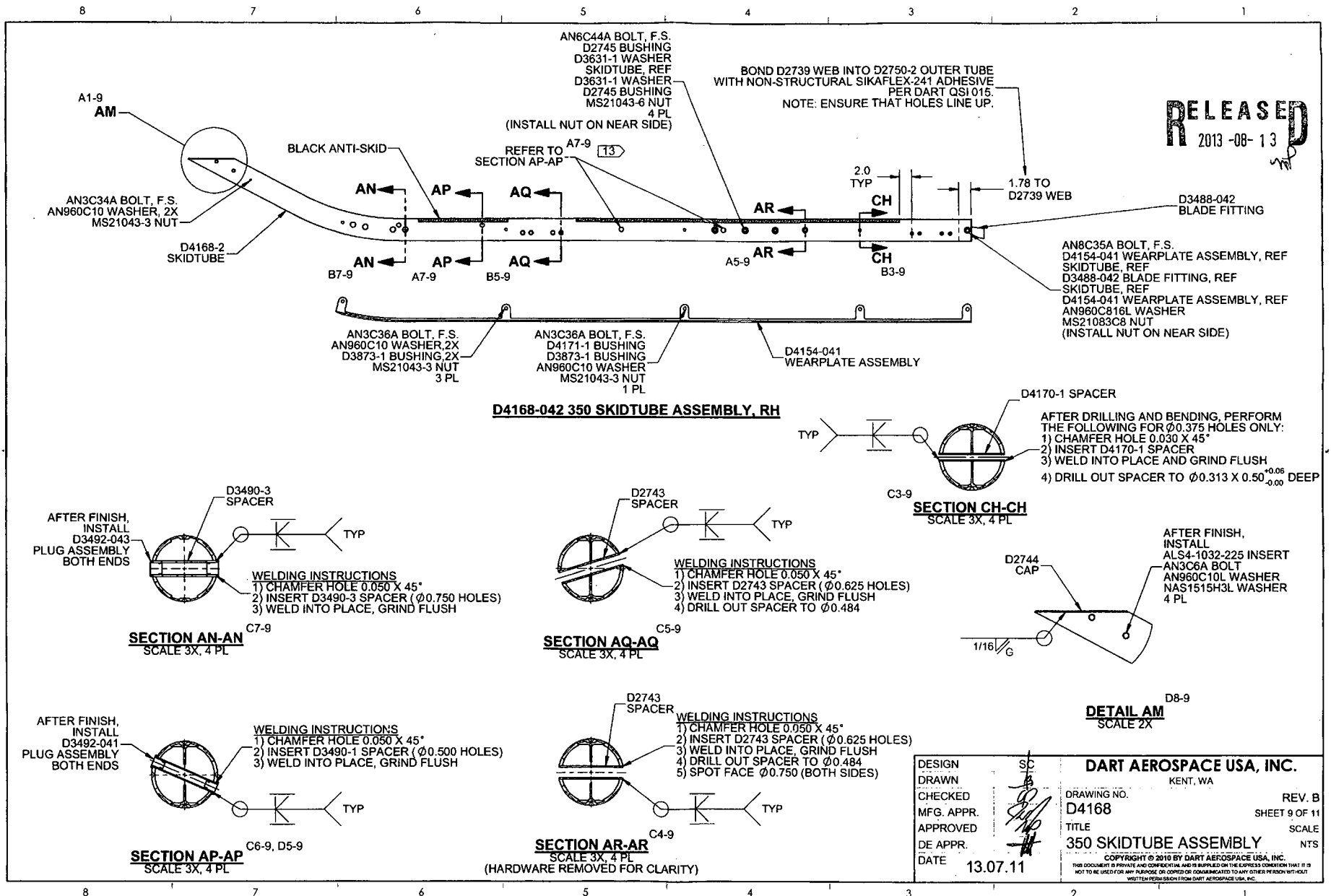
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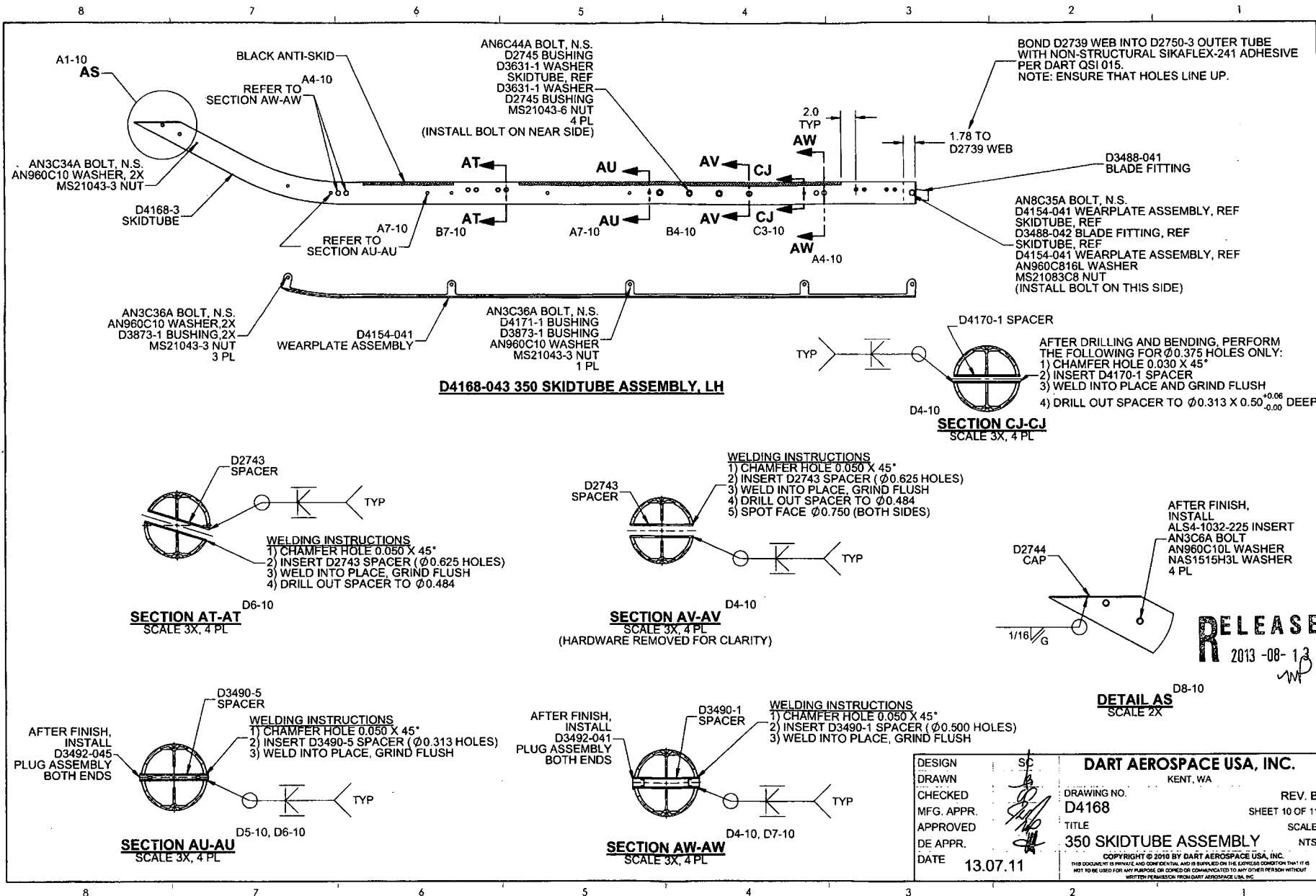
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	JB	KENT, WA	
CHECKED	JP		REV. B
MFG. APPR.	JP	DRAWING NO. D4168	SHEET 7 OF 11
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 SKIDTUBE ASSEMBLY	NTS
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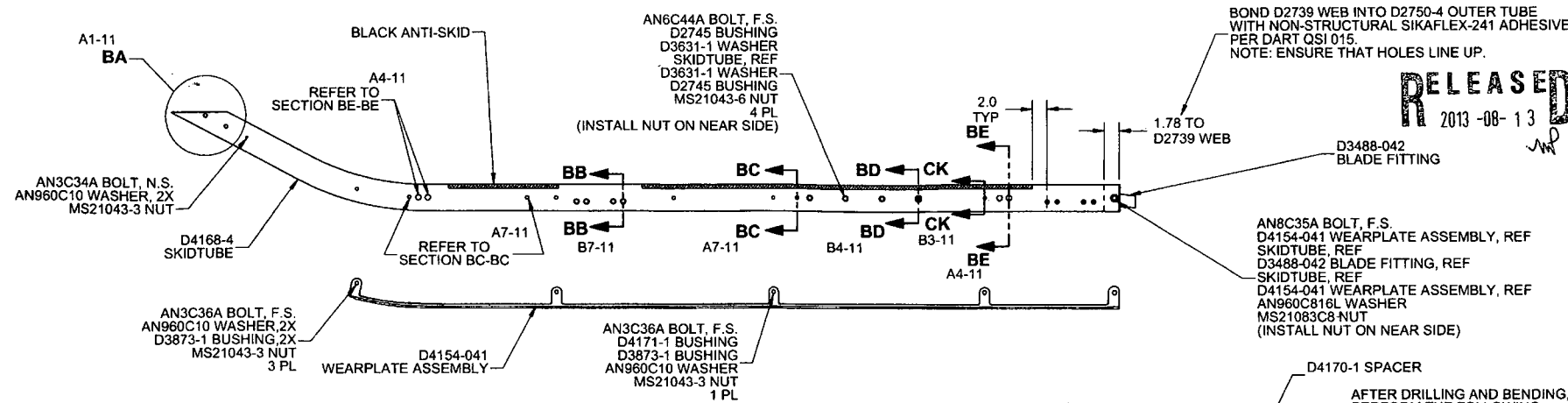


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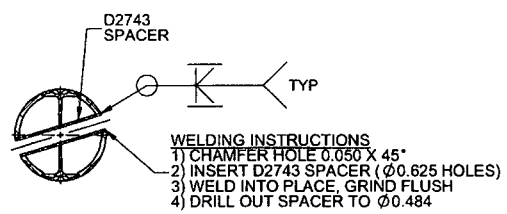




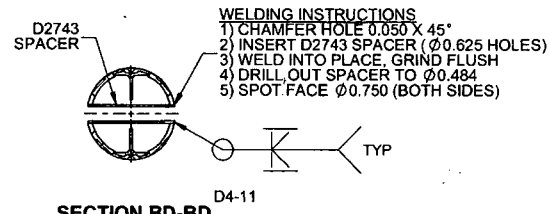
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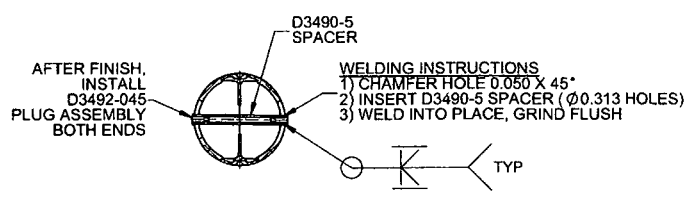
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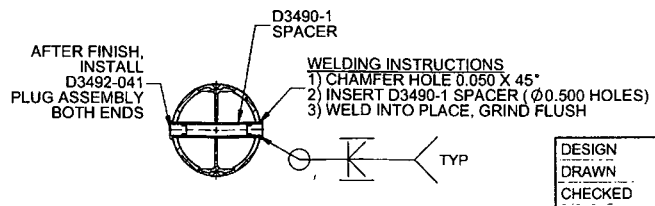
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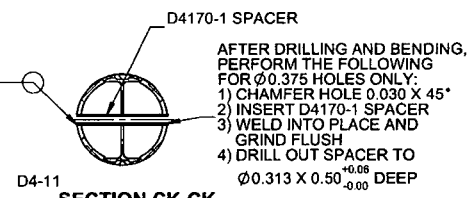
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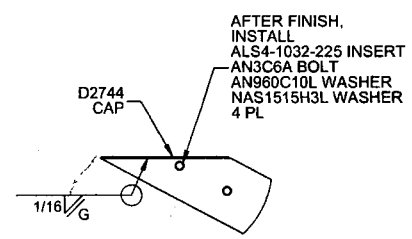
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SECTION BE-BE
SCALE 3X, 4 PL



SECTION CK-CK
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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